



Dart Aerospace Ltd.
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Canada

Tel (613) 632-5200

D3121-143
Job Sheet 171054



Part No: D3121-143

Job Qty: 4 ea

Part Name: Bracket Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/26/18

Job Tracking No:

Created By: Linda Lacelle

Due Date: 1/29/18

Type: Stock

Description:

Note: DWG REV E IPP Rev:Pick:A 04.02.18 New issue KJ/DS IPP Rev:B ECN 1060 07-11-12 DD verified by:EC IPP
Rev:C New Dimensions for Blank Size 08-07-23 JLM Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
					hrs	Hrs			
90	Start up Operation	4 Ea	1/26/18	1/26/18	0.00	0.00	Start Up Machining-1		Kt. 18-01-29
100	Bandsaw	4 pcs	1/26/18	1/26/18	0.00	1.47	Bandsaw1		1/26/18
110	CNC Vertical Machining	4 pcs	1/27/18	1/27/18	0.41	8.51	HAAS1-3		1/27/18
120	QC	4 pcs	1/27/18	1/27/18	0.00	0.00	QC2 Machining-1		1/27/18
130	QC	4 pcs	1/27/18	1/27/18	0.00	0.00	QC8 Machining-1		1/27/18
140	Small Fab	4 pcs	1/29/18	1/29/18	0.00	0.18	Small Fab-2		1/29/18
150	QC	4 pcs	1/29/18	1/29/18	0.00	0.00	QC5		1/29/18
160	Packaging	4 pcs	1/29/18	1/29/18	0.00	0.00	Packaging3-1		1/29/18
170	QC21-SA	4 Ea	1/29/18	1/29/18	0.00	0.00	QC21		1/29/18

Part Op 100 - Cut blanks: (1.250" x 2.000") 4.425" long
Descriptions: 110 - 1-Machine D3121-113 as per Folio FA330 and Dwg D3121
140 - Assemble D3121-143 as per Dwg D3121.

JAN 31 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-B1.250X02.000	17-4 SS Bar 1.250 x 2.00	1.4720 ft (.368 ea)	90-Start up Operation	
D3121-21	Bolt	8 Ea (2 ea)	140-Small Fab	
D3121-241	Bearing Assembly	8 Ea (2 ea)	140-Small Fab	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M17-4-B1.250X02.000	1	14	0
140-Small Fab	D3121-21 5037260	8	9	0
	D3121-241 5024941	8	22	0

Part Specifications

Specifications could not be found.

Plex 1/26/18 11:26 AM dart.lacelle.linda

5030457

DART
AEROSPACE
S036698

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Bracket Assembly

PART NO: D3121-143

Original Serial #: S036698

Revision:

Operation:

Change No:

Start up Operation 01/29/18

Job No: 171054

DART AEROSPACE LTD		Work Order:	171054
Description: Bracket		Part Number:	D3121-113
Inspection Dwg: D3121 Rev: E		Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.080	+/-0.010	.080	✓		Vernier	
0.300	+/-0.010	.302	✓		Vernier	
R0.375	+/-0.010	R.375	✓		Gaborit	
1.54	+/-0.030	1.543	✓		highgage	
0.350	+/-0.010	.356	✓		highgage	
R0.25	+/-0.030	R.250	✓		Gaborit	
Ø0.392	+0.002/-0.000	.393 Ø	✓		micrometre	
Ø0.201	+/-0.010	.200 Ø	✓		Pin gage	
2.540	+/-0.010	2.538	✓		Vernier	
1.590	+/-0.010	1.589	✓		Vernier	
0.160	+/-0.010	.159	✓		Vernier	
0.400	+/-0.010	.396	✓		Vernier	
1.220	+/-0.010	1.217	✓		Vernier	
1.600	+/-0.010	1.601	✓		Vernier	
3.80	+/-0.030	3.800	✓		Vernier	
1.800	+/-0.010	1.800	✓		Vernier	
R0.50	+/-0.030	R.500	✓		425 Gaborit	
0.130	+/-0.010	.130	✓		micrometre	
3.41	+/-0.030	3.383	✓		Vernier	
3.65	+/-0.030	3.630	✓		Vernier	
2.24	+/-0.030	2.210	✓		Vernier	
45°	+/-0.1°	45°	✓		Gaborit	
R0.25	+/-0.030	R.250	✓		Gaborit	
3.97	+/-0.030	3.964	✓		Vernier	
R0.38	+/-0.030	R.380 OK	✓		Gaborit	
Ø0.392	+0.002/-0.000	.393	✓		micrometre	
Ø0.201	+/-0.010	.200 Ø	✓		Pin gage	
0.268	+/-0.010	.265	✓		✓	
R0.260	+/-0.010	R.260	✓		Gaborit	
0.080	+/-0.010	.078	✓		Vernier	
0.300	+/-0.010	.302	✓		Vernier	
0.381	+/-0.010	.387	✓		Vernier	
0.201	+/-0.010	.201	✓		Vernier pin	
0.580	+/-0.010	.587	✓		Vernier	
0.400	+/-0.010	.406	✓		Vernier	

